

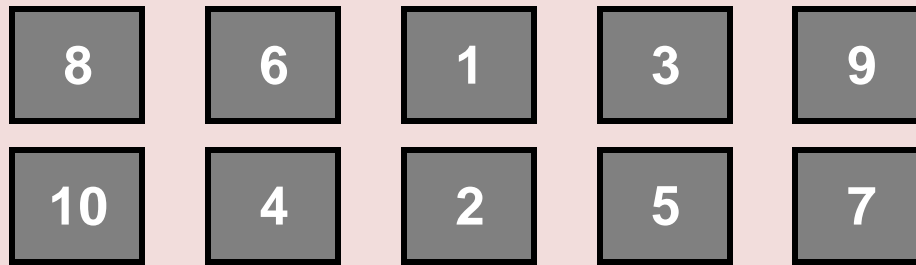
# Cylinder Head Tightening Instructions

# HG1531



	1	2	3	4	5	6
<b>Reference</b>	HG1531					
<b>Piston</b>						

## Headbolt Tightening Sequence



## Fitment Procedure

	Stage 1	Stage 2	Stage 3	Stage 4	Stage 5	Stage 6	Stage 7	Stage 8	Retighten?
<b>Bolt Type 1</b>									
Kilos	4 Kpm	8 Kpm	10.5 Kpm	90°+10.5 Kpm	<>	-90°+10.5Kpm			-90°+10.5Kpm
Pounds	29 lbft	58 lbft	76 lbft	-90°+76 lbft	<>	-90°+76 lbft			-90°+76 lbft
Newton M's	39.2 Nm	78.4 Nm	102.9 Nm	-90°+102.9Nrr	<>	-90°+102.9Nrr			-90°+102.9Nm
<b>Bolt Type 2</b>									
Kilos									
Pounds									
Newton M's									
<b>Bolt Type 3</b>									
Kilos									
Pounds									
Newton M's									
<b>Bolt Type 4</b>									
Kilos									
Pounds									
Newton M's									

## Fitment Key Description of Required Procedure

<b>-/+ X°</b>	Loosen or tighten the head bolt by the 'X'-value specified in the stage. Follow indicated tightening order.
<b>&lt;&gt;</b>	Run the engine until it reaches working temperature. Let the engine cool with the bonnet open for a minimum of four hours. Remove the expansion tank cap. Should retightening be required, loosen by 90° and then retighten observing the tightening procedure above.
<b>Retighten?</b>	If required, should be performed between 620-930 Miles (1000-1500 Km).